

Work Order ID 77031

November-24-11 3:39:10 PM

77031

Page 1

Item ID: D3389-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web
 Start Date: 24/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3389	Rev D

100	Skidtubes	0.00
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100

Skidtubes Memo 0.00

Skidtubes

- 1- Pick D2500-3-100
- 2- Deburr
- 3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut line.
- 4- Cut to finished length
- 5- Open holes to finished size as per dwg D3389
- 6- Deburr

Handwritten: 3 / 11-12-12

110	QC6- Inspect dimensions to drawing	0.00
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110

QC Memo 0.00

Quality Control

Handwritten: DP 11-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77031

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N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

6

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

120

Memo

0.00

HandFinish

Hand Finishing

0.00

130

Memo

0.00

QC

Quality Control

Identify as per dwg & Stock Location: UG

0.00

140

Memo

0.00

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 77031***77031***

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MF
11-12-13

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 77031

77031

Parent Item: D3389-1

D3389-1

Parent Item Name: Web

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A05.08.31New issueKJ/JLM

IPP Rev:B 06-02-08 As per Rev C JLM

IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured

No

100

Each

70.0000

1

6

D2500-3-100

**

Ext'n - 'I' Beam Web 4"

Location

Loc Qty

Loc Code

LG

70

51957

2

66298

68

17-12-12

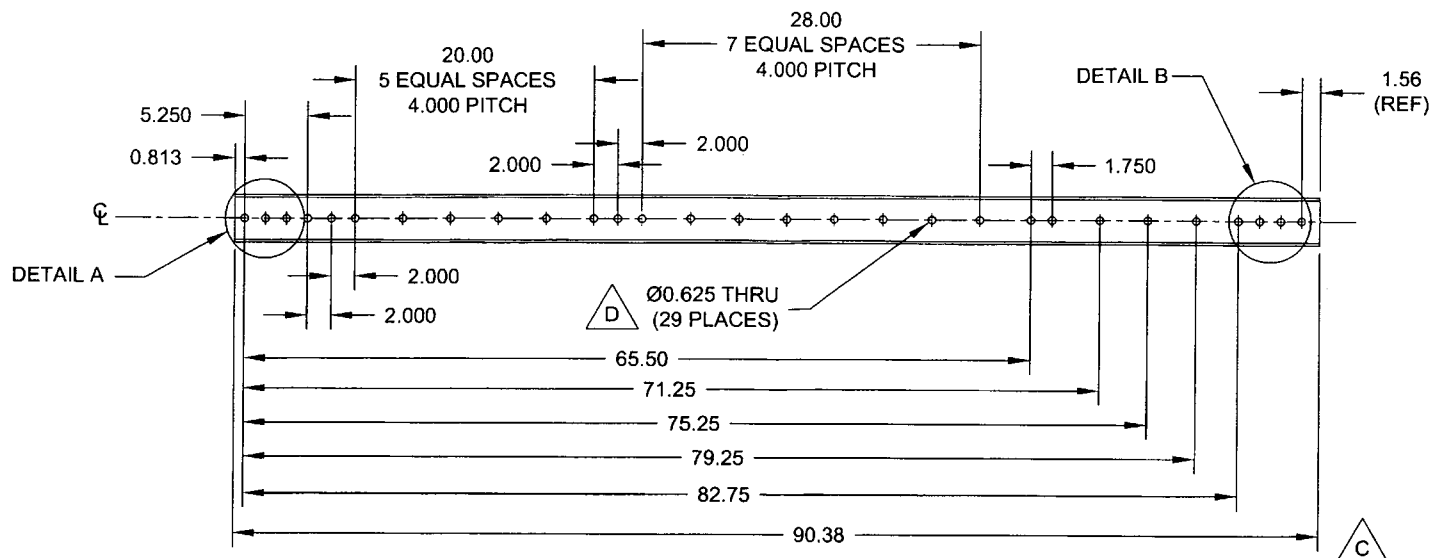
W/O:		WORK ORDER CHANGES					
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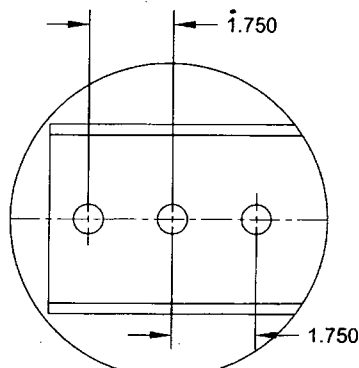
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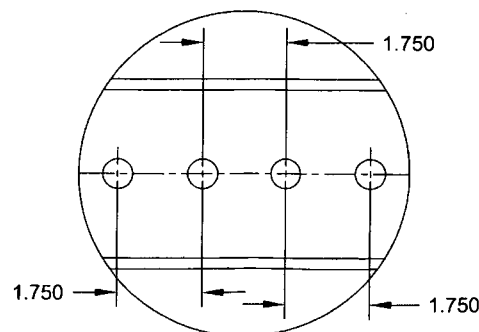
NOTE: Date & initial all entries



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06

SHOP
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **77031**
M.C.J
11/11/24

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3389 REV. D SHEET 1 OF 1 TITLE 412 WEB SCALE 1:10 <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

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